

119-675012

Dart Aerospace Ltd.

Date: Friday, 24/10/2008 10:34:14 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: A119 STEP WELDMENT RH
Job Number	: 42917A	Part Number	: D3043042
Estimate Number	: 10130	Drawing Number	: D3043 REV A
P.O. Number	:	Project Number	: N/A
This Issue	: 24/10/2008 S.O. No. :	Drawing Revision	: A
Prsht Rev.	: NC	Material	:
First Issue	: 11 Type : LARGE FAB ASSY	Due Date	: 20/11/2008 Qty: 4 Um: Each
Previous Run	: 40483A		
Written By	:		
Checked & Approved By	: <u>JUL 08.10.24</u>		
Comment	: Est Rev : A New Issue JLM 05-11-01		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D2622120C	Step Extrusion
Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s) Pick: D2622-120C extrusion Batch: <u>339316</u> → <u>SAD 08/11/12 (4)</u> SAD 08/11/05 (4)		
2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
Comment: LARGE FABRICATION RESOURCE 1 1-Cut D2622-120 extrusion to 120.00" long as per Dwg D3043 using cutting table setup DT8185-G 2-Deburr and bevel ends for welding <u>SAD 08/11/12 (4)</u> SAD 08/11/05 (4)		
3.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP <u>08.11.12 (4)</u> SAD 08/11/05 (4)		
4.0	D2734	Step End Plate
Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s) Pick: Qty Part Number Description Batch <u>B 39179</u> 2 D2734 End Cap <u>B 39179</u> <u>SP 08.11.17 (8X)</u> SP 08.11.07		
5.0	D30401	Mounting Lug
Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s) Pick: Qty Part Number Description Batch <u>B 42944</u> 2 D3040-1 Mounting Lug <u>B 42944</u> <u>SP 08.11.17 (4X)</u> SP 08.11.07		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 24/10/2008 10:34:14 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: A119 STEP WELDMENT RH

Job Number: 42917A

Part Number: D3043042

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0

D30403

Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3040-3 Mounting Lug

B40492
B40492

SP 08.11.17 (8X)
SP 08.11.07 (4X)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld 1 End Cap & Mounting Lugs as per QSI 004 & Dwg D3043 Using DT8808

AR AL ROD Batch:

2-Grind Fwd End Cap weld flush

M109213
M104855

M109213
M104855

08.11.18 (4X)
08.11.11 (4X)
08.11.19 (4X)
08.11.11 (4X)

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08.11.19 (4X)
08.11.19

08.11.11 (4X)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08.11.19

08.11.19 (4X)
08.11.19 (4X)

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Chemical Conversion Coat as per QSI 005 4.1

08.11.19

08.11.19 (4X)

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-1-Weld 1 End Cap as per QSI 004 & Dwg D3043

AR AL ROD Batch:

2-Inspect for foreign object as per QSI 024

M104855

SP 08.11.20 (4X)

08.11.20 (4X)

W/O: 42197A		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3043-042 PAR #: N/A Fault Category: low - lge. NCR: (Yes) No DQA: A Date: 08/12/02
 (D119-675-012) Resolution: Scrap Disposition: Scrap QA: N/C Closed: ✓ Date: 08/12/02

NCR: 42917A		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08-11-11	7.0	1 step scrap. Lugs are 3" too far apart. Employee marked the lines on the step for the lug spacing, in accordance with the drawing, BUT, welded the lugs at the incorrect location. This was caused, by a very similar mark that was on the step, and it resembled the line she had made. R.C. Human error.		Scrap: do the the step. No replace. Ensure to make bigger, move visible lines on the steps when positioning lugs.		08-11-12		
				PAR 08-044 was created to make -041 & -042 weld jigs.		08-11-12		
08-11-12	7.0	The lugs are well below the 0.875" + 0.030" - 0.0" varies from 0.840" - 0.865". Bushing do not install for the assy. R.C. Spacer bushing were removed during welding, and the lugs pulled inwards. Process not certain		Remove both welded ends on the step: Identify the mid section with the original Batch # of the material. Keep the mid sections for the 350 short steps. Steps are scrap Replace on this W/O.	SAD 08-11-12 	08-11-12		

NOTE: Date & initial all entries by new employee.

Restocked 4x 92" long

Date: Friday, 24/10/2008 10:34:14 AM
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Process Sheet

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Drawing Name: A119 STEP WELDMENT RH

Job Number: 42917A

Part Number: D3043042

Job Number:



Seq. #:

Machine Or Operation:

Description:

3-Grind Fwd End Cap weld flush

12.0

QC9

VISUAL WELDING INSPECTION



08/11/24



Comment: VISUAL WELDING INSPECTION

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/11/24 x4 RM

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

(4)

1-Touch up Chemical Conversion Coat as per QSI 005 4.1

FL 08/11/25

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Inspect alodine

08-11-25 (4)

16.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

(4)

START TIME:

2:00

OVEN TEMPERATURE:

320°

FINISH TIME:

2:30

FL 08/11/25

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

m109917

(4)

1-Wing Walk as per Dwg D3043 and QSI 005 4.4

FL 08/11/26

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

JS 08/11/26 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 24/10/2008 10:34:14 AM
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Job Number: 42917A

Part Number: D3043042

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PPP 42917

JS 08/11/2008 (K4)

20.0

QC21

FINAL INSPECTION/W/O RELEASE



08/11/27 AG

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 08/11/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3043	REV. A SHEET 1 OF 2
DATE 01.06.28		TITLE A119 STEP WELDMENT	SCALE NTS
A	01.06.28	NEW ISSUE	

PARTS LIST:

Qty -041	Qty -043	Part Number	Description
X		D3043-041	STEP WELDMENT, LH
	X	D3043-042	STEP WELDMENT, RH
1	1	D2622-120	STEP EXTRUSION
2	2	D3040-1	MOUNTING LUG
2	2	D3040-3	MOUNTING LUG
2	2	D2734	ENDPLATE

NOTES:

- 1) MANUFACTURE FROM D2622-120 EXTRUSION
- 2) WELD PER DART QSI 004. ALL WELDS SHOULD BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004
- 3) FINISH: ACID ETCH & ALODINE ASSEMBLY PER DART QSI 005 4.1
POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT TOP SURFACE OF STEP TO BOTTOM OF TOP
RADIUS PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
01.07.05

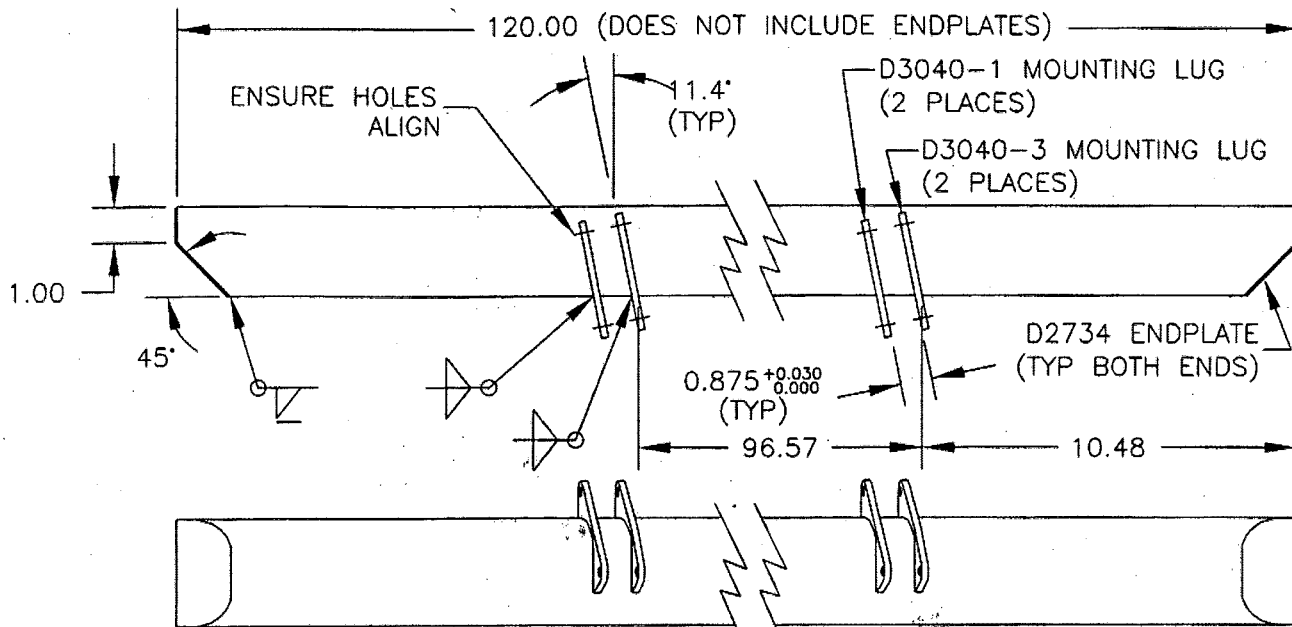
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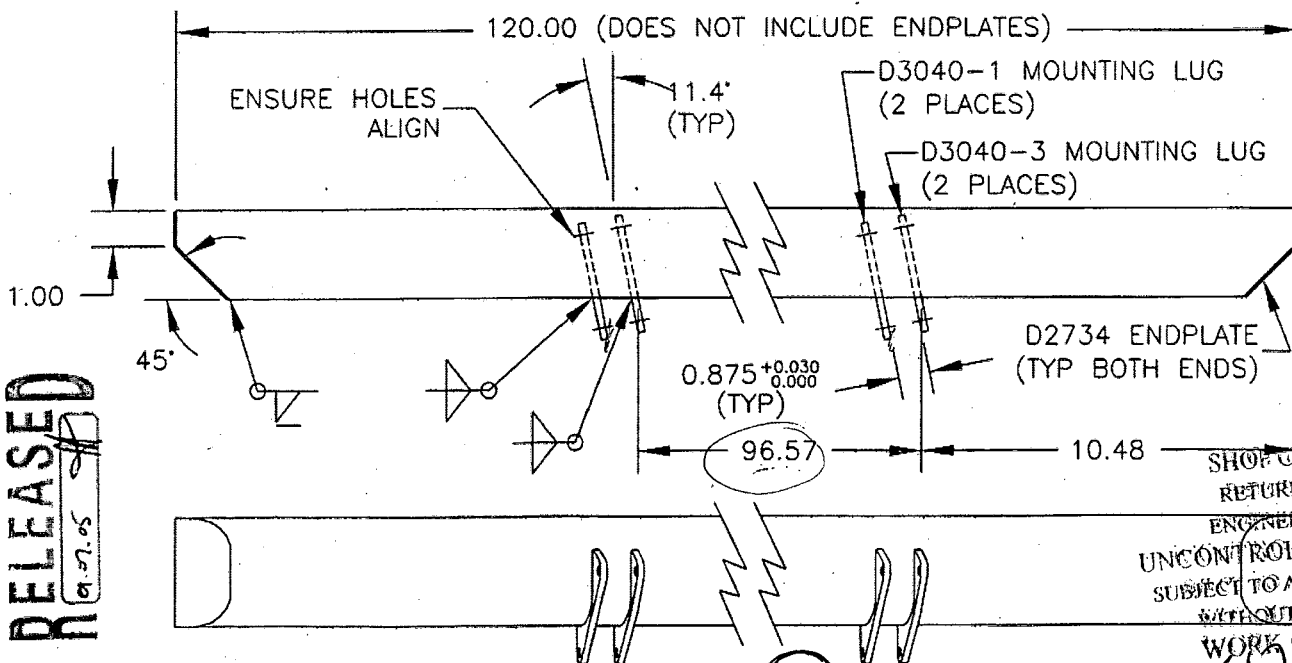
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DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED #	APPROVED #	DRAWING NO. D3043	REV. A SHEET 2 OF 2
DATE 01.06.28		TITLE A119 STEP WELDMENT	SCALE 1:5
A	01.06.28	NEW ISSUE	



VIEW A-A: D3043-041 LH STEP WELDMENT



VIEW A-A: D3043-042 (RH) STEP WELDMENT

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